

Date: Friday, 09/05/2008 1:51:58 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOOR ASSEMBLY
<b>Job Number</b> : 39169C	
<b>Estimate Number</b> : 12353	
<b>P.O. Number</b> :	<b>Part Number</b> : D41269403
<b>This Issue</b> : 09/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D412-694
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : C1
<b>Previous Run</b> : 36652C	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/06/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>JLD 08.5.09</i>	
<b>Comment</b> :	
Est Rev: A 05.12.09 New Issue KJ/RF	
Est Rev: B 06.04.18 New dwg rev. ecn781 EC	
Est Rev: C 06.07.11 Revised per B24660 KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Issue red decal labels for D412-694-03. CHG005

2.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY
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Comment: COMPOSITE ASSEMBLY

D412-694-03 Drill Process

1- Drill pilot holes Ø(#30) using drill Jig D3144-T4 for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T5/T6 as per Dwg D412-694 page 3. Note: Ensure slot is aligned with mark for reference. *080618*

2- Drill Pilot holes Ø(#30) using drill Jig D3120-3T1 for bottom cover. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3. *080617*

3- Drill Pilot holes Ø(#30) using drill Jig DT8703-4 for hinges, top cover and D3131-1 spring. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3 & 4 (view MM-MM). *080617*

4- Drill Pilot holes Ø(#1/8") for clevis base and stop at top of the door using drill Jig DT8703-5. Open (1) hole Ø(#10) 0.193 for clevis base and (2) holes Ø(#19) 0.166 for stop as per Dwg D412-694 page 5 (section FF-FF.) *080617*

5- Drill Pilot hole Ø(#1/8") for clevis base at bottom of the door using drill Jig DT8703-6. Open hole Ø(#10) 0.193 for clevis base as per Dwg D412-694 page 5 (section FF-FF). *080617*

6- Ensure 17 1/16" from opposite edge of the door for Ø5/8" hole is in proper location top and bottom. *080617*

7- Drill through only (1) hole Ø(5/8") and pilot drill (2) holes Ø(#30) for insert. Open (2) holes to 37/64" (0.578) for clevis inserts as per Dwg D412-694 page 5 (section AA-AA). *080617*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: DOOR ASSEMBLY

Job Number: 39169C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

8000528

Insert



Comment: Qty.: 21.0000 Each(s)/Unit Total: 21.0000 Each(s)

Insert

M19443

21

080617

Batch

A/R Hysol EA934NA

M107007

Expiry Date:

090131

080618

4.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM).

2- Sand flush excess Hysol around the insert on both doors.

080619

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

6.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1. Apply Primer filler and reducer around the inserts on both doors.

A/R 11045

Primer Filler

Batch:

108307

A/R 12375S

Reducer

Batch:

105936

ml 08 06 26 (P)

7.0

QC5

INSPECT WORK TO CURRENT STEP

QC5



Comment: INSPECT WORK TO CURRENT STEP

8.0

D31101

Escutcheon



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Escutcheon

Batch

31757

JS 08/05/13 (X)

9.0

D31103

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle

Batch

36724

JS 08/05/13 (X)

W/O: 39169C		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08-02-21	7-0	QC 14 required. Est # 12353 perm. change						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D3111041

Plate Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Plate Assembly

Batch

M10536-17

JS 08/05/13

(XU)

11.0

D31121

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Guide

Batch

35122

JS 08/05/13

(XU)

12.0

D31131

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Spring

Batch

B36728

JS 08/05/13

(XU)

13.0

D31141

Pivot



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pivot

Batch

B36726

JS 08/05/13

(XU)

14.0

D31165

Seal



Comment: Qty.: 5.6700 f(s)/Unit Total: 5.6700 f(s)

Seal 110-031-4

Batch

B23699

JS 08/05/13

(XU)

15.0

D311611

Seal



Comment: Qty.: 1.5000 f(s)/Unit Total: 1.5000 f(s)

SEAL

Batch

B24697

JS 08/05/13

(XU)

16.0

D3119041

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cover Assembly

Batch

27724

JS 08/05/13

(XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D31201

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cover, Flat Pattern

Batch

10563-17

JS 08/05/13 (XU)

18.0

D31203

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cover

Batch

B18658A

JS 08/05/13 (XU)

19.0

D31251

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

D3125-1 Lever

Batch

M10536-17

JS 08/05/13 (XU)

20.0

D31253

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lever

Batch

M10536-17

JS 08/05/13 (XU)

21.0

D31255

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lever

Batch

M10536-17

JS 08/05/13 (XU)

22.0

D31257

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lever

Batch

M10536-17

JS 08/05/13 (XU)

23.0

D31291

Lever



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Lever

Batch

M10536-17

JS 08/05/13 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: DOOR ASSEMBLY

Job Number: 39169C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D31301

Clevis Base



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clevis Base

Batch

M10536-17

AS 08/05/13 (XU)

25.0

D31311

Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Stop

Batch

M10536-17

AS 08/05/13 (XU)

26.0

D31341

Rod



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rod

Batch

27338

AS 08/05/13 (XU)

27.0

D31343

Rod



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

D3125-3 Rod

Batch

18376

AS 08/05/13 (XU)

28.0

D314007

Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Door Kit

Batch

~~M10536-17~~ 39169D

AS 08/02/20

29.0

D31431

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Clevis

Batch

M10536-17

AS 08/05/13 (XU)

30.0

D31433

Clevis



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Clevis

Batch

M10536-17

AS 08/05/13 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 39169C

Part Number: D41269403

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	D31441	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

18816

AS 08/05/13 (X)

32.0	D3144105	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

23143

AS 08/05/13 (X)

33.0	D3144107	Doubler
------	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

23144

AS 08/05/13 (X)

34.0	D31451	Bracket
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

B20582

Re enter  
Comp won't let me  
take it out!  
AS 08/05/13 (X)

35.0	D31461	Bracket
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

Batch

B20699

AS 08/05/13 (X)

36.0	D31471	Pin
------	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

30824

AS 08/05/13 (X)

37.0	D31491	Striker Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

Batch

M10536-12

AS 08/05/13 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169C

Part Number: D41269403

Job Number:



Seq. #:	Machine Or Operation:	Description :
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38.0	D31501	Guide
------	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guide

Batch

M10536-17

AS 08/05/13 (XU)

39.0	D31541	Key
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Key

Batch

M10536-17

AS 08/05/13 (XU)

40.0	D31571	Spacer
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

M10536-17

AS 08/05/13 (XU)

41.0	D3159041	Bracket Assembly
------	----------	------------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Batch

19641

AS 08/05/13 (XU)

42.0	D3159043	Bracket Assembly
------	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

24859

AS 08/05/13 (XU)

43.0	AN52510R7	Screw
------	-----------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M1060166

AS 08/05/13 (XU)

44.0	AN960JD6L	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

5519

AS 08/05/13 (XU)

W/O: ~~39~~ 39169C

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
080716	42.	Replace 3159-043/044 WITH D3159-041 REMOVE STEP 9 of Seq# 77.0 IAW E-Mail from R.F	<i>[Signature]</i>	080716	1		

Part No: D412-693-03 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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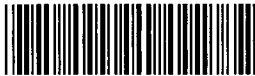
Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

45.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

M107091

AS 08/05/13 (X)

46.0

AN960JD8L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

M16956

AS 08/05/13 (X)

47.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch

M107715

AS 08/05/13 (X)

48.0

AN960JD10L

Washer



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

Batch

M104885

AS 08/05/13 (X)

49.0

AN960JD10LL

Washer



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Washer

Batch

M19600

AS 08/05/13 (X)

50.0

ALS463280

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Insert

Batch

M17841

AS 08/05/13 (X)

51.0

BSP45

Commercial Rivet



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Commercial Rivet

Batch

M107296

AS 08/05/13 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

BSP46

Commercial rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Commercial rivet

Batch

M101237

AS 08/05/13 (XL)

53.0

FW4032

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Washer

Batch

M101203

AS 08/05/13 (XL)

54.0

FW10032

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

Batch

M19249

AS 08/05/13 (XL)

55.0

M7885344

Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rivets

Batch

M19099

AS 08/05/13 (XL)

56.0

M7885345

Rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rivet

Batch

1108

AS 08/05/13 (XL)

57.0

MS203921C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pin

Batch

M18822

AS 08/05/13 (XL)

58.0

MS203922C11

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pin

Batch

M14149

AS 08/05/13 (XL)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

59.0

MS203922C15

Pin



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pin

Batch

M101340

JS 08/05/13 (X)

60.0

MS21042L3

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Nut

Batch

M167644

JS 08/05/13 (X)

61.0

MS21042L06

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

M107898

JS 08/05/13 (X)

62.0

MS24665151

Cotter Pin



Comment: Qty.: 11.0000 Each(s)/Unit Total : 11.0000 Each(s)

Cotter Pin

Batch

M14526

JS 08/05/13 (X)

63.0

MS24694C4

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

M15924

JS 08/05/13 (X)

64.0

MS24694S53

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

Batch

M15798

JS 08/05/13 (X)

65.0

MS24694S56

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

Batch

M104407

JS 08/05/07 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 09/05/2008 1:51:58 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169C

Part Number: D41269403

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

66.0	MS24694S60	Screw
------	------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Screw  
Batch: M104407

AS 08/05/13 (XU)

67.0	MS25281R6	Clamp
------	-----------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Clamp  
Batch: M19098

AS 08/05/13 (XU)

68.0	MS27039106	Screw
------	------------	-------



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)  
Screw  
Batch: M106815

AS 08/05/13 (XU)

69.0	MS27039108	Screw
------	------------	-------



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Screw  
Batch: M106889

AS 08/05/13 (XU)

70.0	MS35206231	Screw
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Screw  
Batch: M11735

AS 08/05/13 (XU)

71.0	MS35650305T	Nut
------	-------------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Nut  
Batch: M11786

AS 08/05/13 (XU)

72.0	MS518597	Washer
------	----------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)  
Washer  
Batch: M106421

AS 08/05/13 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 09/05/2008 1:51:59 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

73.0

NAS116910L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch

M11753

JS 08/05/13 (X)

74.0

NAS38868P

Screw



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Screw

Batch

M19098

JS 08/05/13 (X)

75.0

NAS391B6P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch

M19098

JS 08/05/13 (X)

76.0

NAS43DD340

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch

M11737

JS 08/05/13 (X)

77.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-03 Assembly Process

1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

JS 080709

2- Install D3111-041 Plate Assembly. If needed, install temporary D3110-3 Handle as per Dwg D412-694 page 5 (view W and section BB-BB). Note: Adjust D3111-041 high with washer as required. Check that the D3154-1 key doesn't touch the base of the door.

JS 080710

3- Assemble Rod as per Dwg D412-694 page 5 (view W)

JS 080710

4- Assemble D3147-1 Pin to the lever as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

JS 080710

5- Connect Rods and D3111-041 Plate Assembly as per Dwg D412-694 page 5 (view W).

JS 080710

6- Install D3111-041 and mechanism in place. Use D3110-3 Handle to make lock and mechanism of the rod work properly. Mark the center NAS1169-10L washer into the door and drill (#10) Ø0.193". C'sink Ø0.385 x

JS 080710

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

100° from far side of the door. Ensure D3111-041 is level with inside door surface as per Dwg D412-694 page 5 (view W).

7- Install (1) D3159-041 bracket assembly to side of the window. Transfer hole from the door to D3159-041 bracket. Drill Ø(#30) C'sink for the rivet (note: use 1" pitch holes) as per Dwg D412-694 page 5 (view W) and (section LL-LL).

A 080715

8- Drill (#19), C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps.

A 080715

9- Install (1) D3159-043 bracket assembly. Transfer (2) holes from the door to the bracket. Install (1) M7885/3-4-5 rivet and install the second rivet with the doubler.

Note: Layout properly as per Dwg D412-694 page 5 (view W). Note: Second hole will be done with doubler and seal.

N/A

10- Drill (4) (#10) Ø0.193" holes from D3150-1 guide by laying out doublers with temporary seal segment with strike plate. Check location of strike plate by laying out small and large door together. Note: Position strike plate when big door is in locked position.

A 080715

11- Open (#30) pilot hole to Ø"G" (0.261) in the door for ALS4-632-80 insert. Install insert as per Dwg D412-694 page 3.

A 080716

12- Install Doublers and D3159-041 bracket. Cut slot openings from the door to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ)

A 080716

13- Install D3150-1 Guide top/bottom as per Dwg D412-694 page 5 (view DD & CC).

A 080716

14- Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM).

A 080716

15- Install top/bottom Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3.

A/R RTV732 Clear

Batch: M108652

Expiry Date: 090717

A 080718

FOR D412-694-011 ONLY

16- Drill Pilot holes Ø(#1/8") for D3119-041 cover using drilling Jig D3119-041T1/T2 as per Dwg D412-694 page 3. Trim D3119-041 Cover Assembly and transfer Ø(#30) holes using hole finder tool from the door to the cover. Open holes to Ø5/32" (0.156).

A 080716

78.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 09/05/2008 1:51:59 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169C

Part Number: D41269403

Job Number:



Seq. #:

Machine Or Operation:

Description :

79.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

(Put red label inside before putting the cover D3119-041/or Vip trim)

*080718*

1- Install D3119-041 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly.

80.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Don't do it*

81.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*888 39169*

*u 08.08.25*

82.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/08/25*

Job Completion



*u 08.08.25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D412-694-01	DOOR ASSEMBLY
	X			D412-694-02	DOOR ASSEMBLY
		X		D412-694-03	DOOR ASSEMBLY
			X	D412-694-04	DOOR ASSEMBLY
		1	1	D3110-1	ESCUTCHEON
		1	1	D3110-3	HANDLE
1	1			D3110-5	HANDLE ASSEMBLY
		1	1	D3111-041	PLATE ASSEMBLY
		2	2	D3112-1	GUIDE
		1	1	D3113-1	SPRING
		1	1	D3114-1	PIVOT
1	1			D3115-1	BRACKET
		1	1	D3116-11-0180	SEAL
		1	1	D3116-5-0680	SEAL
1	1			D3116-7-0680	SEAL
1	1			D3116-9-0770	SEAL
		1		D3119-041	COVER ASSEMBLY
		1		D3119-042	COVER ASSEMBLY
		1		D3120-1	COVER
		1		D3120-2	COVER
		1		D3120-3	COVER
		1		D3120-4	COVER
3	3			D3121-041	BRACKET ASSEMBLY (ROLLER)
1				D3121-043	BRACKET ASSEMBLY (ROLLER)
	1			D3121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOCK
1	1			D3124-2	HOCK
		1	1	D3125-1	LEVER
		1	1	D3125-3	LEVER
		1	1	D3125-5	LEVER
		1	1	D3125-7	LEVER
1	1			D3126-1	BRACKET (SLIDER)
1	1			D3126-3	BRACKET (SLIDER)
5	5			D3126-5	BRACKET (SLIDER)
1	1			D3127-1	SPACER
		1	1	D3128-1	SHIM
		2	2	D3129-1	LEVER
		2	2	D3130-1	CLEVIS BASE
		1	1	D3131-1	STOP
1				D3132-041	ROD WELDMENT
	1			D3132-042	ROD WELDMENT
	1			D3133-041	ROD WELDMENT
1				D3133-042	ROD WELDMENT
		1	1	D3134-1	ROD
		1	1	D3134-3	ROD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
1				D3138-1	COVER
	1			D3138-2	COVER
1	1			D3139-1	GUARD
1				D3139-3	GUARD
	1			D3139-4	GUARD
1				D3140-05	DOOR
	1			D3140-06	DOOR
		1		D3140-07	DOOR
			1	D3140-08	DOOR
2	2			D3141-1	SPRING
		1	1	D3143-1	CLEVIS
		3	3	D3143-3	CLEVIS
		1		D3144-1	DOUBLER
1				D3144-3	DOUBLER
		1		D3144-105	DOUBLER
		1		D3144-107	DOUBLER
1				D3144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
		1		D3144-117	DOUBLER
		1		D3144-121	DOUBLER
		1		D3144-119	DOUBLER
	1			D3144-123	DOUBLER
1	1			D3144-13	DOUBLER
		1		D3145-1	HINGE BRACKET
		1		D3145-2	HINGE BRACKET
		1		D3146-1	HINGE BRACKET
		1		D3146-2	HINGE BRACKET
		2	2	D3147-1	PIN
2	2			D3148-1	CLEVIS
		2	2	D3149-1	STRIKER PLATE
		2	2	D3150-1	GUIDE
1	1			D3151-041	DOUBLER ASSEMBLY
1				D3152-041	BRACKET ASSEMBLY
	1			D3152-042	BRACKET ASSEMBLY
		1	1	D3154-1	KEY
1	1			D3155-041	BRACKET ASSEMBLY
1	1			D3155-042	BRACKET ASSEMBLY
2	2			D3156-1	BRACKET
		2	2	D3157-1	SPACER
		3	3	D3159-041	BRACKET ASSEMBLY
		1		D3159-043	BRACKET ASSEMBLY
			1	D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1		1		D3162-043	BRACKET ASSEMBLY
1		1		D3162-044	BRACKET ASSEMBLY
1				D3163-041	COVER ASSEMBLY
	1			D3163-042	COVER ASSEMBLY
1				D3183-041	BRACKET ASSEMBLY (ROLLER)
	1			D3183-042	BRACKET ASSEMBLY (ROLLER)
1	1			D3203-1	HANDLE ASSEMBLY
2	2			D3308-1	DOUBLER
55	55	21	21	80-005-2-8	INSERT (OR SL2052-3-4)
10	10			AN625-10F6	SCREW
8	8	4	4	AN625-10F7	SCREW
		8	8	AN660JD10	WASHER
18	18	4	4	AN660JD10L	WASHER
13	13	32	32	AN660JD10LL	WASHER
6	6			AN660JD416L	WASHER
		4	4	AN660JD6L	WASHER
6	6			AN660JD8	WASHER
		2	2	AN660JD8L	WASHER
		2	2	AN660JD8LL	WASHER
		10	10	ASL4-632-80	INSERT
87	87	50	50	BSP45	RIVET
		12	12	FW10-032	WASHER
		6	6	FW4-032	WASHER
12	12			M7885/2-4	RIVET (OR CR3213-4-3)
		3	3	M7885/3-4	RIVET (OR CR3212-4-3)
		2	2	MS20392-1C11	PIN
		7	7	MS20392-2C15	PIN
2	2			MS20392-2C17	PIN
2	2	2	2	MS20392-2C9	PIN
2	2			MS20392-3C21	PIN
8	8			MS20426AD3	RIVET
12	12			M7885/3-4	RIVET
8	3			MS20426AD4	RIVET

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
20	20			MS20426AD4	RIVET
		6	6	MS21042L05	NUT
6	6	2	2	MS21042L08	NUT
		5	5	MS21042L3	NUT
4	4			MS21042L4	NUT
4	4			MS21072L3	NUTPLATE
6	6	9	9	MS24665-151	COTTER PIN
4	4			MS24693-S271	SCREW
		2	2	MS24694-C4	SCREW
4	4			MS24694-C5	SCREW
6	6			MS24694-S5	SCREW
18	18			MS24694-S50	SCREW
		4	4	MS24694-S55	SCREW
		2	2	MS24694-S53	SCREW
		4	4	MS24694-S60	SCREW
4	4			MS24694-S68	SCREW
		2	2	MS25281-F6	CLAMP
2	2	2	2	MS27039-1-05	SCREW
14	14	12	12	MS27039-1-06	SCREW
13	13	6	6	MS27039-1-08	SCREW
		2	2	MS35205-231	SCREW
2	2			MS35275-233	SCREW
2	2			MS35649-264	NUT
		4	4	MS36650-305T	NUT
2	2			MS36650-3252	NUT
2	2	3	3	MS51859-7	WASHER
		4	4	NAS1169-10L	WASHER
		14	14	NAS368-S-8P	SCREW
		15	15	NAS391B6P	WASHER
7	7			NAS430D3-10	SPACER
6	6			NAS430D3-14	SPACER
		2	2	NAS430D3-40	SPACER

# GENERAL NOTES:

- FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D3124-1/2 HOOK RESTS AGAINST CUTOUT SHOWN IN VIEW N.
- IF REQUIRED, NOTCH D3125-1 LEVER (REF) TO CLEAR THE D3130-1 CLEVIS BASE (REF. 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- HOLES AND PARTS TO BE LOCATED PER DRILLING JIGS, B30-23000-01; D3144-T1/T2-T3; D18703-3; D3162-041T1 (FOR -01 DOOR ASSY); B30-23000-02; D3144-T7-T8-T9; D18703-9; D3162-041T2 (FOR -02 DOOR ASSY); D3144-T4-T5-T6; D3119-041T1; D3112-T1/T2 (FOR -03 DOOR ASSY); D3144-T10-T11-T12; D3119-042T1; D3112-T1/T2 (FOR -04 DOOR ASSY).
- INSTALL INSERTS PER DART QSI 005. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.
- IDENTIFY D412-694-01/-02/-03/-04 DOOR ASSEMBLIES USING D2729-1 DECALS.

CI	06.03.28	ADD OPTION M7885/3-4
C	05.11.23	ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	02.05.21	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	#	APPROVED #
DATE	05.11.23	TITLE DOOR ASSEMBLY
		DRAWING NO. D412-694
		REV. C
		SHEET 1 OF 6
		SCALE NTS

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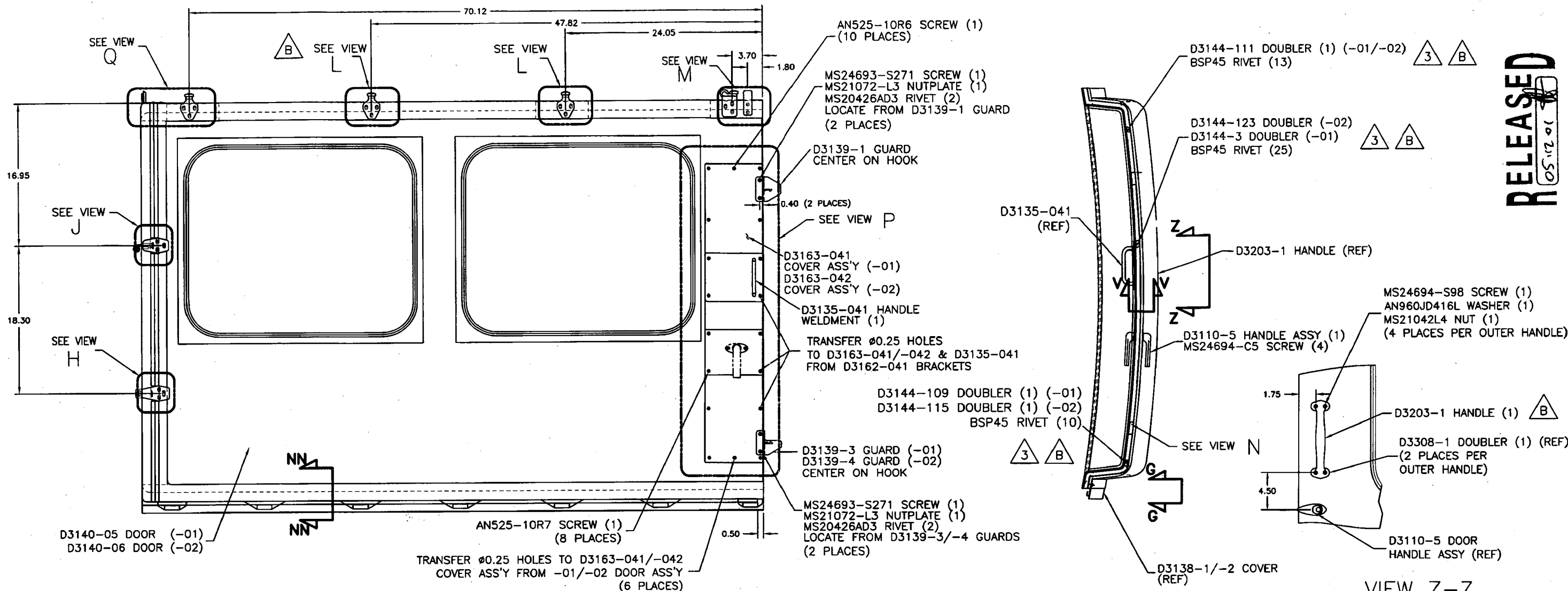
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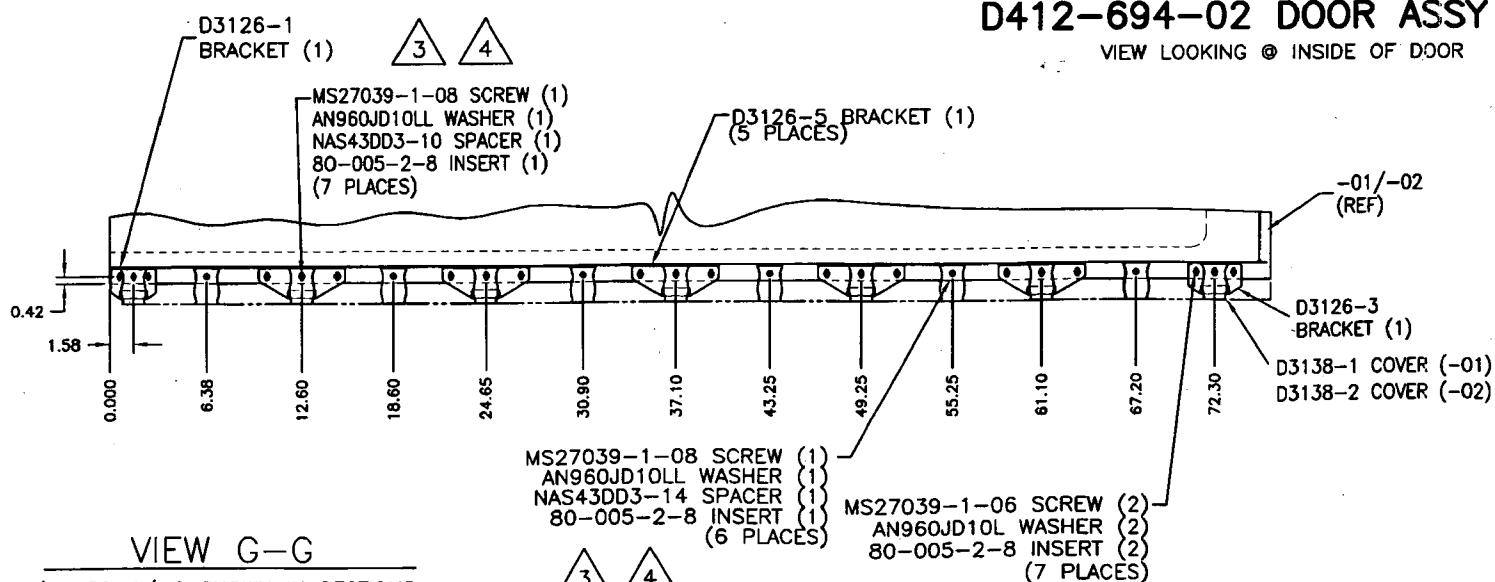
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05.11.23



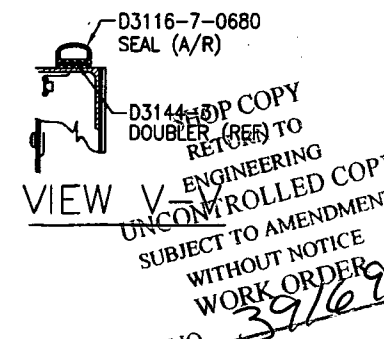
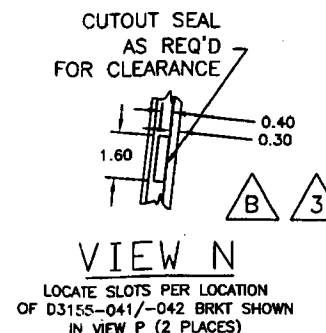
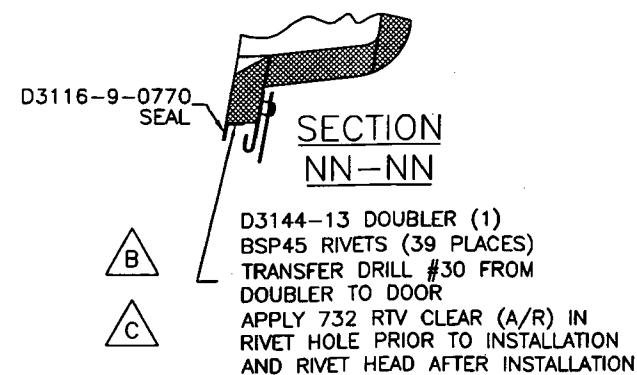
**D412-694-01 DOOR ASSY (SHOWN)**  
**D412-694-02 DOOR ASSY (OPP.)**

VIEW LOOKING @ INSIDE OF DOOR

**VIEW Z-Z**  
**OUTER DOOR HANDLE INSTALLATION**

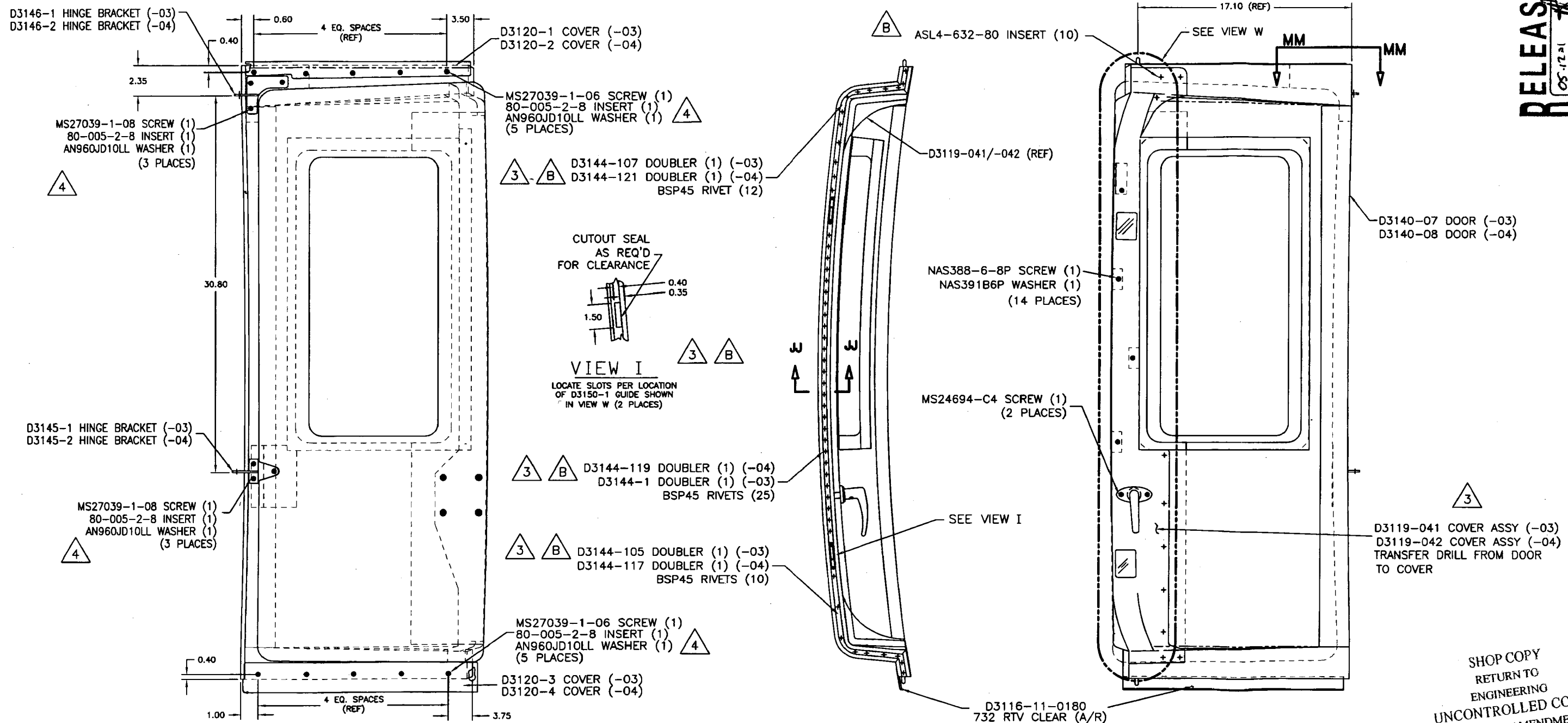


**VIEW G-G**  
 (D3138-1/-2 SHOWN IN SECTIONS FOR CLARITY OF HDWR LOCATIONS)



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	CP	RF			
	CHECKED	APPROVED	DRAWING NO.		REV. C
	DATE		D412-694		SHEET 2 OF 6
	05.11.23		TITLE	SCALE	
			DOOR ASSEMBLY	NTS	

RELEASED  
05-12-21

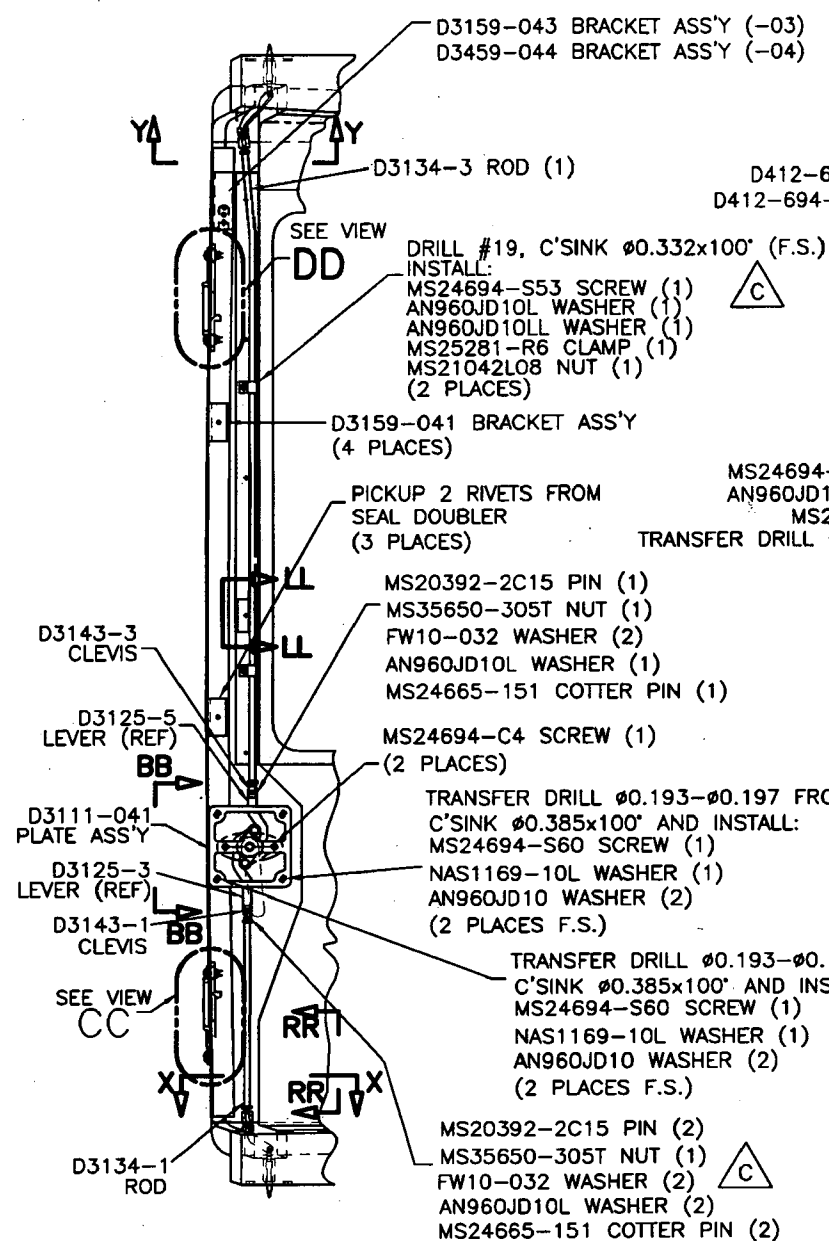


**D412-694-03 DOOR ASSY (SHOWN)**  
**D412-694-04 DOOR ASSY (OPP)**

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 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 39169C

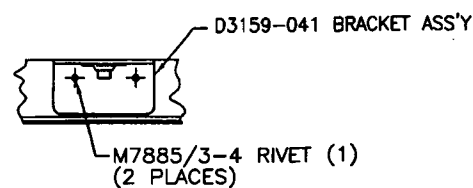
SECTION JJ-JJ

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DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE NTS	



VIEW W

D3119-041/-042 COVER ASS'Y NOT SHOWN FOR CLARITY  
SEAL ALSO NOT SHOWN FOR CLARITY



SECTION LL-LL  
(3 PLACES)  
VIEW ROTATED 90°CCW

D3150-1 GUIDE (1)  
LOCATE BY ALIGNING  
D412-694-03/-04 SLOTS IN  
D412-694-01/-02 CUTOUT A/R  
FOR CLEARANCE

D3128-1 SHIM  
(A/R)

MS24694-S56 SCREW (1)  
AN960JD10LL WASHER (1)  
MS21042L3 NUT (1)  
TRANSFER DRILL  $\phi 0.191$  TO DOOR  
(2 PLACES)

VIEW DD  
VIEW CC (SIMILAR)

SEAL (REF)

D3149-1 STRIKER PLATE

RECESS DOOR FOR  
INSTALLATION OF  
D3112-1 GUIDE LEAVE  
0.040" AROUND D3112-1  
BRACKET TO ALLOW  
FOR ADJUSTMENT.  
FAIR IN FOAM USING  
HYSOL EA934 ADHESIVE

D3147-1 PIN

-03/-04 (REF)

AN525-10R7 SCREW (1)  
80-005-2-8 INSERT (1)  
(2 PLACES)

D3112-1 GUIDE

D3125-7 LEVER

SECTION AA-AA

DRILL #10 ( $\phi 0.193$ )  
D3130-1 CLEVIS BASE (1)  
MS27039-1-06 SCREW (1)  
AN960JD10LL WASHER (1)

D3125-1 LEVER 0.20 (REF)

D3125-1 LEVER (TOP)  
D3125-7 LEVER (BOTTOM)

MS35650-30ST NUT (1)

D3134-1/-3 ROD (REF)

D3143-3 CLEVIS

SECTION FF-FF

PICKUP FROM DOUBLER

M7885/3-4 RIVET (1)

VIEW RR-RR

D3125-5 LEVER

MS20392-2C11 PIN (1)  
AN960JD10LL WASHER (2)  
MS24665-151 COTTER PIN (1)  
FW10-032 WASHER (2)  
(2 PLACES)

NAS43DD3-40FC SPACER (1)  
(2 PLACES)

D3157-1 SPACER (1)  
(2 PLACES)

D3110-3 HANDLE (1)

D3154-1 KEY (1)  
AN960JD10LL WASHER (1)  
MS51859-7 WASHER (3)  
MS21042L3 NUT (1)

D3129-1 LEVER (2 PLACES)

AN960JD10LL WASHER (SHIMMED A/R, 4 PLACES)

D3110-1 ESCUTCHEON (1)

D3111-041 PLATE ASS'Y (REF)

SECTION BB-BB

VIEW SHOWN WITH MECHANISM  
IN THE UNLOCKED POSITION  
FOR CLARITY

1.25

FF

D3130-1 CLEVIS BASE (REF)

1.70

D3112-1 GUIDE (REF)

0.50

0.78

FF

B 3

SECTION X-X (SHOWN)

SECTION Y-Y (SIMILAR)

D3125-1 LEVER NOT SHOWN FOR CLARITY

RELEASED  
05-12-01

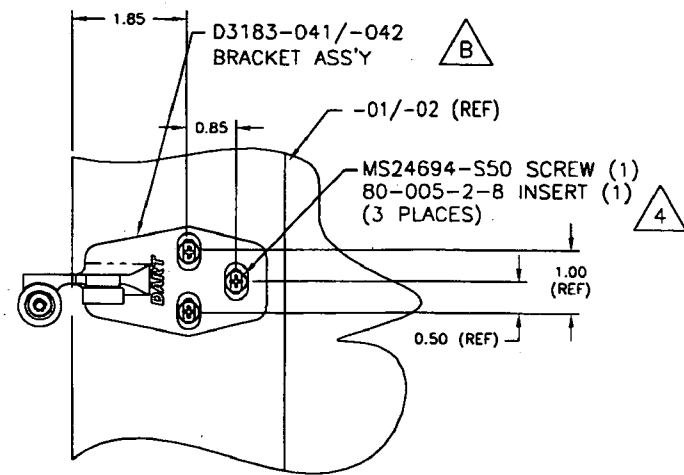
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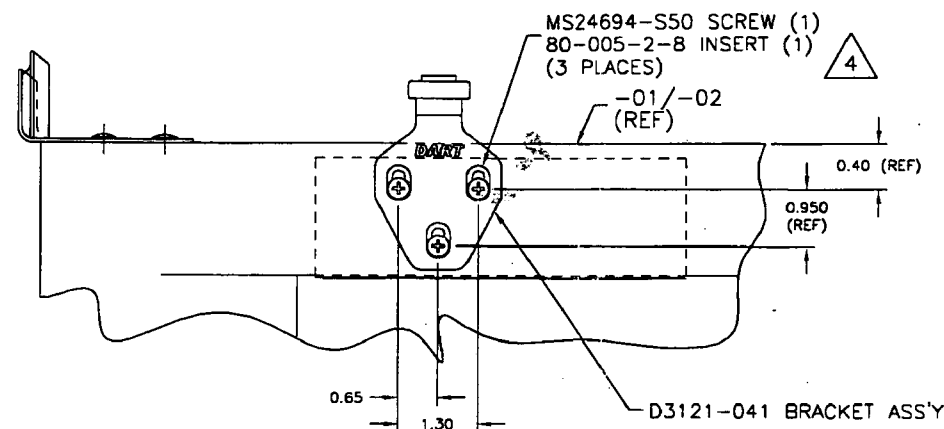
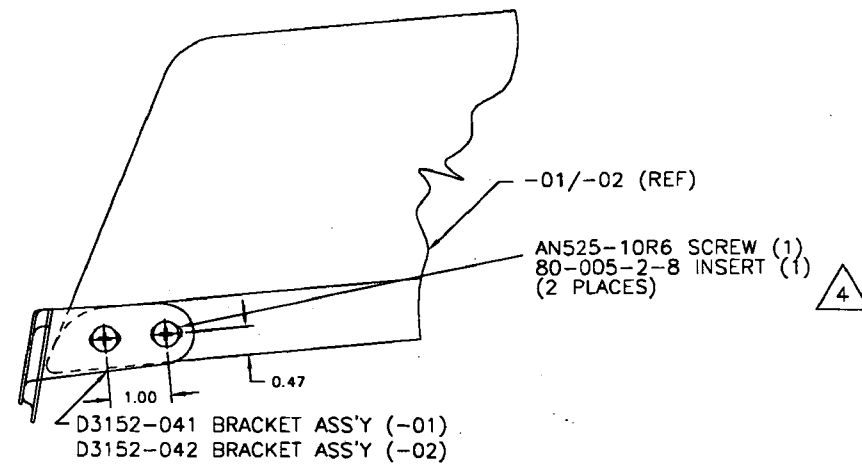
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DATE 05.11.23		TITLE DOOR ASSEMBLY	SCALE NTS

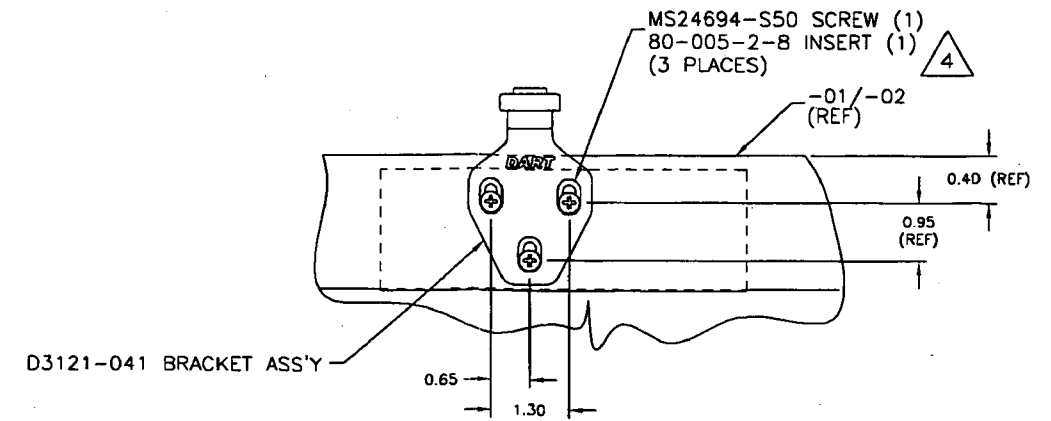




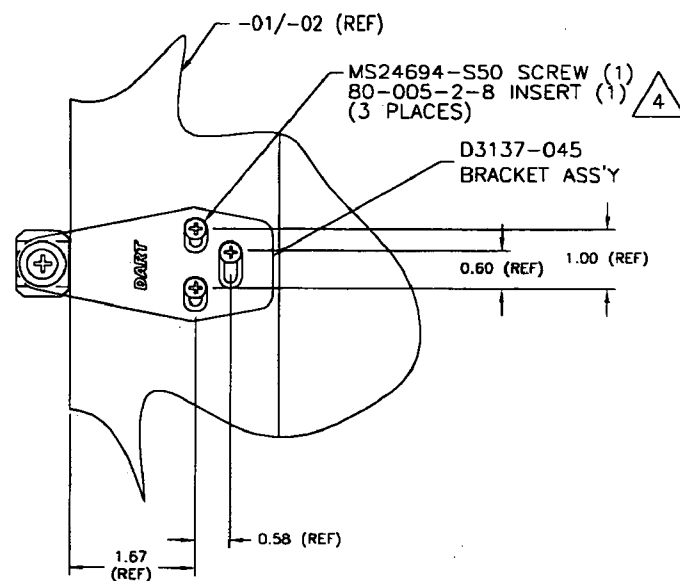
VIEW J



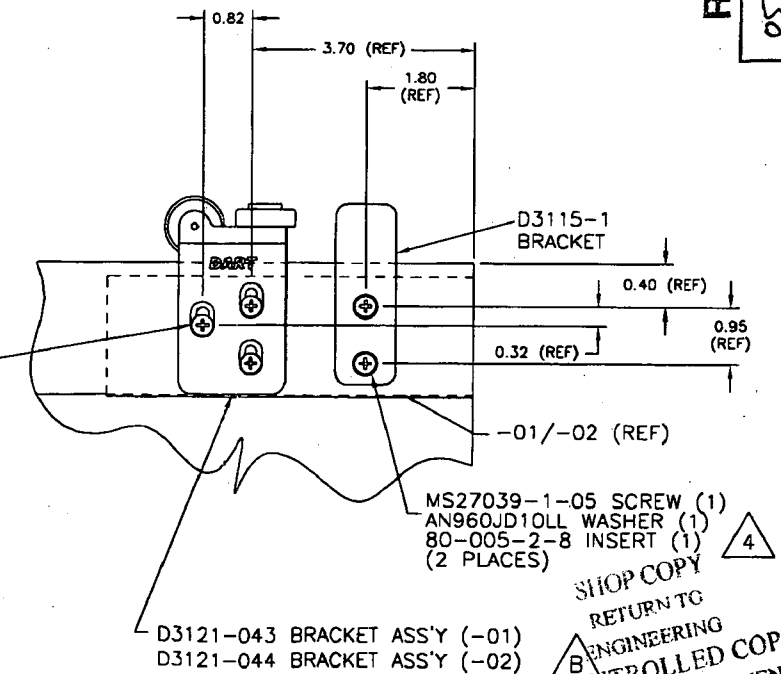
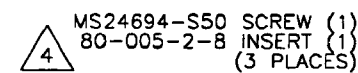
VIEW Q



VIEW L



VIEW H



VIEW M

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CHECKED #	APPROVED #	DRAWING NO. D412-694	REV. C SHEET 6 OF 6
DATE 05.11.23	TITLE DOOR ASSEMBLY	SCALE NTS	

**Dan Stow**

---

**From:** Mike Petsche [mpetsche@dartaero.com]  
**Sent:** July 16, 2008 11:32 AM  
**To:** 'Dan Stow'; 'Roberto Fuentes'  
**Subject:** RE: spacedoor nuplates

uuh...ok....

Yes.

---

**From:** Dan Stow [mailto:dstow@dartaero.com]  
**Sent:** July 16, 2008 11:35 AM  
**To:** 'Roberto Fuentes'  
**Cc:** 'Mike Petsche'  
**Subject:** RE: spacedoor nuplates

Mike – just say yes and all will be good.

**Dan Stow**  
**Technical Support**  
**Dart Aerospace**  
**Tel: 613.632.5200**  
**Cell: 613.676.0992**  
**dstow@dartaero.com**

---

**From:** Roberto Fuentes [mailto:rfuentes@dartaero.com]  
**Sent:** July 16, 2008 11:30 AM  
**To:** 'Dan Stow'  
**Cc:** Mike Petsche  
**Subject:** RE: spacedoor nuplates

If Mike is ok with the replacement of this bracket I am ok too, because will create of alter IIN/ICA. Make sure D3159-041 bracket doesn't interfere with function of D3149-1 striker plate.

Roberto

---

**From:** Dan Stow [mailto:dstow@dartaero.com]  
**Sent:** Wednesday, July 16, 2008 8:44 AM  
**To:** 'Roberto Fuentes'  
**Subject:** FW: spacedoor nuplates

16/07/2008

10/10/10 10:10 AM  
10/10/10 10:10 AM  
10/10/10 10:10 AM  
10/10/10 10:10 AM

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10/10/10 10:10 AM  
10/10/10 10:10 AM

Hi Roberto,

Please send an email to confirm that Russ can replace the D3159-043/-044 brackets with D3159-041 bracket.

**Dan Stow**  
**Technical Support**  
**Dart Aerospace**  
**Tel: 613.632.5200**  
**Cell: 613.676.0992**  
**dstow@dartaero.com**

---

**From:** Dan Stow [mailto:dstow@dartaero.com]  
**Sent:** July 15, 2008 5:17 PM  
**To:** 'Roberto Fuentes'  
**Subject:** spacedoor nuplates

Hi Roberto,

If you look at pic 004 you will see where the nutplate is currently located. We measured from the slot to the nutplate (10" – 4") at 6 inches. At this location the screw will enter the plastic at such an angle that the head of the screw will be touching on one side and not the other.

Pic 003 is one proposal we have which would move the nutplate down past the curve on the plastic. Location is 2 inches from the slot.

Pic 006 is the proposal we think is best for two reasons. First reason is that we are only moving the nutplate by 3.25" and it will still be out of the curve on the plastic. Second reason is that with the D3159-043/044 brackets the installer must install one rivet before installing the outside doubler and then one after. With the D3159-041 brackets both rivets can be installed at the same time, thus eliminating the need to manufacture the D3159-043/ 044 brackets.

**Dan Stow**  
**Technical Support**  
**Dart Aerospace**

16/07/2008



DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12639
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Point de départ		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
28/04/2008	08/06/2006	4699	C. Lavoie		PO00001429		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC135-0019	D3140-06 Door Right Non Assy ( Grosse ) Job: 42212			
1	0	1	DKC135-0020	D3140-08 Door Right Non Assy ( Petite ) Job: 42212			
1	0	1	DKC135-0017	D3140-05 Door Left Non Assy ( Grosse ) Job: 42210			
1	0	1	DKC135-0018	D3140-07 Door Left Non Assy ( Petite ) Job: 42210			
<div>Revised Added work order</div>							

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department


AQ-357



Date: Lundi, 2007-11-12 10:54:08  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : DOOR	
Numéro Job : 42212		Numéro Article : <del>DKC135-0010/-0011</del>	DAC135-0019
Numéro Soumission : 1726		Numéro Dessin : D3140	DKC135-0020
Numéro B.A. :		Projet Numéro : DKC135	
Cette fois : 2007-11-12	No. B.V. :	Révision dessin : F	
Prsht Rev. : NC		Matériel : Tissu Fibercote E-761/7788	
Prem. fois :	Type :	Date Dûe : 2007-10-11	Qté: 1 Udm: UNITE
Job précédente : 42211			

Écrit par : 



Vérifié & Approuvé par : \_\_\_\_\_

Commentaires : N° de pièce Dart Aerospace: D3140-06/-08  
N° de pièce Delastek Aeronautique: DKA359-0010/-0011  
N° de pièce Delastek Composites: DKC135-0010/-0011

Process Sheet Rév.: 11 Changer la révision de dessin pour la Rév.:  
F



## Produit additionnel

Numéro Job: 

# Séq.:	Machine ou Opération:	Description :
1.0	OUTILLAGE	OUTILLAGE NÉCESSAIRE À LA FABRICATION
		


Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
OUTILLAGES NÉCESSAIRES À LA FABRICATION DE LA PIÈCE

Moule N° B30-23000-02T  
Patron de découpe N° B30-23000-57T  
Patron de découpe N° B30-23000-61T  
Patron de découpe N° B30-23000-63T  
Patron de découpe N° B30-23000-69T  
Patron de découpe N° B30-23000-71T  
Patron de découpe N° B30-23000-73T  
Patron de découpe N° B30-23000-75T  
Patron de découpe N° B30-23000-77T  
Patron de découpe N° B30-23000-79T  
Gabarit de taillage N° B30-23000-06T ( 2 pièce ) et N° B30-2300-04T  
Forme de silicone N° B30-23000-08T

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
		

Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
PRÉPARATION DU MOULE














Préparation du moule selon la section 5.0 de l'instruction de travail TEC-77

Quantité: 1 Date: 23-11-07 Sceau: 






















Date: Lundi, 2007-11-12 10:54:08

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: DOOR	
Numéro Job: 42212		Numéro Article: DKC135-0010/-0011	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
3.0	AMB0211	PREPERG FIBERCOTE E761/7781 roul. 50"	
Commentair Qty.: 12.3 VERGE(s)/Unit Total : 12.3 VERGE(s) PREPERG FIBERCOTE E761/7781 roul. 50"			
N° de Lot: <u>1-6293-1</u>			
4.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs DÉCOUPAGE MATÉRIEL			
Découpe du tissu pré-imprégné e-761 paquets de 10.5 pi². ( 7 paquets =24.5 Verges )			
Quantité: <u>1</u> Date: <u>26/11/07</u> Sceau:    			
5.0	DRAPAGE 1	DRAPAGE DART	
			
Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs DRAPAGE DES PIECES			
Faire le drapage de 3 plis de tissu pré-imprégné e-761 ( 4 Paquets ) selon la section 8.1.1 de l'instruction de travail N° TEC-77.			
Quantité: <u>1</u> Date: <u>26/11/07</u> Sceau:    			
6.0	AC0409	Tissu à délaminer Release ply B	
Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s) Tissu à délaminer Release ply B			
7.0	AC0407	Wrightlon 5200 Bleu P3	
Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s) Wrightlon 5200 Bleu P3			
8.0	AC0408	Feutre de drainage N° Airweave N 10	
Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s) Feutre de drainage N° Airweave N 10			
9.0	AC0755	Sac à vide N° Strechlon 700	
Commentair Qty.: 7.770 METRE CAR(s)/Unit Total : 7.770 METRE CAR(s) Sac à vide N° Strechlon 700			
10.0	AC0098	Ruban à gommer jaune #: T/AT-200Y	
Commentair Qty.: 2.0000 RL(s)/Unit Total : 2.0000 RL(s) Ruban à gommer jaune #: T/AT-200Y			

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: DOOR	
Numéro Job: 42212		Numéro Article: DKC135-0010/-0011	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
11.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs EFFECTUER LA POCHE A VIDE  Faire le montage cuisson selon la section 8.2.1 de l'instruction de travail N° TEC-77.  Quantité: <u>6</u> Date: <u>26/11/07</u> Sceau:    			
12.0	CUISSON 1	CUISSON PIÈCE DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs CUISSON DES PIECES  Faire la cuisson selon la section 8.3.1 de l'instruction de travail N° TEC-77  Inscrire le N° de cuisson: <u>5741</u>  Quantité: <u>1</u> Date: <u>26/11/07</u> Sceau:    			
13.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs DÉMOULAGE DES PIECES  Retirez le montage cuisson et faire les retouches de la pièce, afin d'enlever les surplus de résines et les résidus de tissu à délaminer.  Quantité: <u>1</u> Date: <u>27-11-07</u> Sceau:   			
14.0	INSPECTION 3	INSPECTION PIÈCE DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs INSPECTION GÉNÉRALE  Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.  Quantité: <u>1</u> Date: <u>27-11-07</u> Sceau: 			



## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42212

Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.: Machine ou Opération: Description :

15.0 ACP0006 Rohacell 71S 1"thick 49.2" x 98.4" plain

Commentair Qty.: 2.00 UNITE(s)/Unit Total: 2.00 UNITE(s)  
Rohacell 71S 1"thick 49.2" x 98.4" plain

N° de Lot: 1-6290-1

1-5733-1

16.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 360.0000Min Total Run: 6.0000Hrs  
DÉCOUPAGE PRIMAIREFaire la découpe des pièces de mousse structurales ( Rohacell ) sur la scie à ruban selon la section 8.1.2  
de l'instruction de travail N° TEC-77.

Quantité: 1 Kit

Date: 27-11-07

Sceau:



17.0 SÉCHAGE SÉCHAGE DU MATÉRIEL

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
SÉCHAGE DU MATÉRIEL

Faire le séchage du Rohacell selon les informations du manufacturier

Inscrire le N° de cuisson: 5742

Quantité: 1

Date: 27-11-07

Sceau:



18.0 AAC0560 FILM ADHESIF PF-7035-C

Commentair Qty.: 55 UNITE(s)/Unit Total: 55 UNITE(s)  
FILM ADHESIF PF-7035-C

N° de Lot: 1-6282-1



19.0 ACP0003 Core splice adhesive MA560.048

Commentair Qty.: 5 UNITE(s)/Unit Total: 5 UNITE(s)  
Core splice adhesive MA560.048

N° de Lot: 2-6292-1



20.0 AAC0563 EPOCAST 87269-A/B

Commentair Qty.: 0.25 KIT(s)/Unit Total: 0.25 KIT(s)











EPOCAST-87269-A/B ADTECH P-17

27-11-07

N° de Lot: 6420



Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: DOOR	
Numéro Job: 42212		Numéro Article: DKC135-0010/-0011	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
21.0	AAC0645	DOUBLER KIT D3140-6-8	
Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) DOUBLER KIT D3140-6-8 1-6408-2, 1-6309-8, 1-6313-2, 1-6421-1 N° de Lot: 1-6326-2, 1-6408-5, 1-6408-4, 1-6309-2			
22.0	NETTOYAGE 3	NETTOYAGE COMPOSITES DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs NETTOYAGE GÉNÉRALE  Faire le nettoyage des doublers selon l'instruction générale N° I.G. # Lavage pièce aluminium traité alodine. Quantité: 1 Kit Date: 28-11-07 Sceau:   Quantité: _____ Date: _____ Sceau: _____			
23.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs ASSEMBLAGE GÉNÉRALE DES PIÈCES  Mise en place des doublers et des pièces de mousse structurales selon la section 8.1.3 de l'instruction de travail N° TEC-77. Quantité: 1 Date: 28-11-07 Sceau:    			
24.0	AC0409	Tissu à délaminer Release ply B	
Commentaire Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s) Tissu à délaminer Release ply B			
25.0	AC0407	Wrightlon 5200 Bleu P3	
Commentaire Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s) Wrightlon 5200 Bleu P3			
26.0	AC0408	Feutre de drainage N° Airweave N 10	
Commentaire Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s) Feutre de drainage N° Airweave N 10			
27.0	AC0755	Sac à vide N° Strechlon 700	
Commentaire Qty.: 7.770 METRE CAR(s)/Unit Total : 7.770 METRE CAR(s) Sac à vide N° Strechlon 700			
28.0	AC0098	Ruban à gommer jaune #: T/IAT-200Y	
Commentaire Qty.: 2.0000 RL(s)/Unit Total : 2.0000 RL(s) Ruban à gommer jaune #: T/IAT-200Y			

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42212

Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.: Machine ou Opération: Description :

29.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.2 de l'instruction de travail N° TEC-77

Quantité: 1

Date: 28/11/07

Sceau:



30.0 CUISSON 1 CUISSON PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
CUISSON DES PIECES

Faire la cuisson des pièces selon la section 8.3.2 de l'instruction de travail N° TEC-77

Quantité: 1

Date: 28/11/07

Sceau:



31.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
DÉMOULAGE DES PIECES

Retirez le montage cuisson de sur la pièce, et enlever les résidus de ruban adhésif en teflon et les barres d'aluminium, Garder seulement la barre qui sépare les deux pièces.

Quantité: 1

Date: 29-11-07

Sceau:



32.0 DÉCOUPE CORE DÉCOUPE DU CORE DART



Commentair Setup: 0.00Hrs/ Run: 210.0000Min Total Run : 3.5000Hrs  
USINAGE DES MOUSSE

Usinage des mousses sturcturales selon la section 8.1.4 de l'instruction de travail N° TEC-77

Quantité: 1

Date: 29-11-07

Sceau:



33.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
INSPECTION GÉNÉRALE


Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étape.

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.	Nom Dessin: DOOR
Numéro Job: 42212	Numéro Article: DKC135-0010/-0011

Numéro Job: 

# Séq.:	Machine ou Opération:	Description :
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Quantité: 1 Date: 30-11-07 Sceau: 

34.0	AMB0211	PREPERG FIBERCOTE E761/7781 roul. 50"
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Commentaire Qty.: 12.3 VERGE(s)/Unit Total : 12.3 VERGE(s)  
PREPERG FIBERCOTE E761/7781 roul. 50"



N° de Lot: 1-0293-1

35.0	DRAPAGE 1	DRAPAGE DART
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Commentaire Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs  
DRAPAGE DES PIECES

Drapage de la coquille intérieur selon la section 8.1.5 de l'instruction de travail N° TEC-77

Quantité: 3-12-07 Date: 1 Sceau:  

36.0	AC0409	Tissu à délaminer Release ply B
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Commentaire Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)  
Tissu à délaminer Release ply B

37.0	AC0407	Wrightlon 5200 Bleu P3
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Commentaire Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)  
Wrightlon 5200 Bleu P3

38.0	AC0408	Feutre de drainage N° Airweave N 10
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Commentaire Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)  
Feutre de drainage N° Airweave N 10

39.0	AC0755	Sac à vide N° Strechlon 700
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Commentaire Qty.: 7.770 METRE CAR(s)/Unit Total : 7.770 METRE CAR(s)  
Sac à vide N° Strechlon 700

40.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
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Commentaire Qty.: 2.0000 RL(s)/Unit Total : 2.0000 RL(s)  
Ruban à gommer jaune #: T/AT-200Y

41.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs  
EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.3 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 3-12-07 Sceau:  

Le: Lundi, 2007-11-12 10:54:09

Isatour: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42212

Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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42.0	CUISSON 1	CUISSON PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
CUISSON DES PIECES

Faire la cuisson de la pièce selon la section 8.3.3 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 3-12-07 Sceau:



43.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
DÉMOULAGE DES PIECES

Retirez le montage cuisson, et faire de retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissu à délaminer.

Retirer la pièce du moule.

Quantité: 1 Date: 10-12-07 Sceau:



44.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
TRIMAGE DE FINITION

Faire le trimage de finition de la pièce selon la section 8.5 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 13-12-07 Sceau:



45.0	AAC0671	Dupont Primer N° 1104S
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77048 9.5. 18.01.08



Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-6254-2

46.0	AAC0670	Dupont Activation N° 7975S
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77755

Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)  
Dupont Activation N° 7975S N° de Lot: 1-6473-1

47.0	AAC0672	Dupont Reducer N° 12375S
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Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: N/A

le: Lundi, 2007-11-12 10:54:09

lisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42212

Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.: Machine ou Opération: Description :

48.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
PRÉPARATION DU MATÉRIEL

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

16-01-08



49.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
INSPECTION PIÈCE DART

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnel"

Date: 16-01-08 Sceau:



Initiales: N.S.

50.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
APPLICATION DE PRIMER

Appliquer une épaisse couche de primer partout sur les deux portes.

Quantité: 1

Date: 16-01-08

Sceau:



D3140-06 MA

51.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
APPLICATION DE PRIMER

Appliquer une épaisse couche de primer partout sur les deux portes.

Quantité: 1

Date: 24-01-08

Sceau:



D3140-08

52.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs  
FINITION GÉNÉRALE

Faire un sablage léger ( Grit 320-400 ) de toute les surfaces.

Quantité: 1

Date: 25-01-08

Sceau:



4

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42212

Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.: Machine ou Opération: Description :  
53.0 AAC0671 Dupont Primer N° 4104S 77048 7.5. 18-01-08  
Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-6254-2

54.0 AAC0670 Dupont Activator N° 7975S 7715  
Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)  
Dupont Activator N° 7975S N° de Lot: 1-6473-1

55.0 AAC0672 Dupont Reducer N° 12375S  
Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: N/A

56.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
PRÉPARATION DU MATÉRIEL

JAN 2 5 2008

Nettoyage qty 1

JAN 2 5 2008

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

18-01-07

57.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
APPLICATION DE PRIMER

JAN 2 5 2008

Application d'une couche de primer de finition partout sur les deux portes.

Quantité: 1 Date: 18-01-07 Sceau: D3140-06

58.0 IDENTIFICATION4 IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
IDENTIFICATION DES PIÈCES

Identifier le numéro de la pièce, le numéro de job ainsi que la date de fabrication sur l'aluminium peinturé dans le dégagement des mécanisme de porte.

Grosse porte : D3140-06

Petite Porte: D3140-08

Quantité: 1 Date: 18-01-08 Sceau:

te: Lundi, 2007-11-12 10:54:09

isateu: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42212

Numéro Article: DKC135-0010/-0011

Numéro Job:



# Séq.: Machine ou Opération: Description :

59.0


INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
INSPECTION GÉNÉRALE

Inspection finale par le département de la qualité selon le dessin D3140.

Date: 28-01-08 Sceau:  Initiales: *J.S.*

60.0

EMBALLAGE 3

EMBALLAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage selon la section 8.7 de l'instruction de travail N° TEC-77

Quantité: *2 pièces* Date: 28-01-08 Sceau: 